



NOTES:

1. THIS IS A ULTRA- HIGH VACUUM COMPONENT (UHV)
2. WHEN MACHINING VACUUM PARTS, USE OF SILICONE AND SULPHUR-BASED CUTTING FLUIDS IS PROHIBITED. USE ONE OF THE FOLLOWING:  
A) CIMCOOL 5 STAR 49  
B) TRIM SOL
3. ALL SURFACES MUST BE MACHINED FOR CLEAN UP
4. FINISHING: WHEN MACHINING VACUUM PARTS USE OF ABRASIVE PAPER OR SANDING DISCS, BUFFING OR POLISHING COMPOUNDS, OR RESIN-BONDED GRINDING WHEELS IS PROHIBITED
5. CLEANING: THE COMPONENT MUST BE CLEANED SUCH THAT A UHV PRESSURE OF  $1 \times 10^{-9}$  TORR CAN BE ACHIEVED
6. HANDLING: THE COMPONENTS SHALL BE HANDLED WITH WHITE SILK GLOVES AND WRAPPED WITH ALUMINUM FOIL TYPE DRY ANNEAL AND UNDER CLEAN ROOM CONDITIONS
7. DO NOT BREAK SHARP EDGE
8. DIMENSIONS IN [ ] ARE INCHES AND FOR REF. ONLY

1	4X R4.5 [.18] WAS 8X R1.5 [.06]			
	4X R1.5 [.06] WAS 8X R1.5 [.06]	M.J.M.		
SYM	CHANGE DESCRIPTION	BY	CHKD	DATE
REVISIONS				

ITEM	DWG/PART NUMBER	NOMENCLATURE OR DESCRIPTION	MATERIAL / SPEC	QTY
PARTS LIST				
UNLESS OTHERWISE SPECIFIED ALL DIMENSIONS ARE IN MILLIMETERS TOLERANCES DECIMALS ANGLES X .7 [0.03] .25° XX .25 [0.01] XXX .12 [0.005]		LOG NUMBER <b>A2534601</b>	THIS DRAWING IS THE PROPERTY OF <b>ARGONNE NATIONAL LABORATORY</b>	
SURFACE ROUGHNESS 1.6 [63]	DESIGNED BY SHU/MUSCIA	DATE 9/17/96	CHIEF DESIGN ENGINEER D. SHU	DATE 11/16/96
REMOVE ALL BURRS AND BREAK SHARP EDGES .03 MAX.	CHECKED BY SHU/CHANG	DATE 11/16/96	GP LEADER M. KUZAY	DATE 11/16/96
SURFACE TEXTURE TO BE IN ACCORDANCE WITH LATEST ANSI B46.1	DESIGNER SHU/MUSCIA	DATE 9/17/96	PROJECT MGR.	
MACHINING & TOLERANCING IN ACCORDANCE WITH LATEST ANSI Y14.5	RESPONSIBLE ENGINEER D. SHU	DATE 11/16/96	APPROVE/D/RELEASED	
MATERIAL 304 STAINLESS STEEL		SCALE 1:1	SHEET 1 of 1	DRAWING NUMBER P4105091005-400003-01
DO NOT SCALE DRAWING				